

Work Order ID 80720

80720

Page 1

February-28-12 10:36:09 AM

Item ID: D4155-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bar
 Start Date: 28/02/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 13/03/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/28 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4155	B								

100 0.00
 100
 Cold Saw Memo
 Hyd Mech Cut blanks at 91.59" 0.00
 12/04/04 4

110 0.00
 110
 HAAS I Memo
 HAAS CNC vertical machine #1 1-Mill as per folio FB048 & dwg D4155,
 FOLIO REV: _____
 DWG REV: _____
 2-Deburr as required
 Manual Mill 0.00
 12/04/04 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4155-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 28/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 13/03/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

12-04-05

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

12/04/05

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: *W/N*

0.00

140

Packaging

Memo

0.00

Packaging

12-4-5 *(x4)*

Dart Aerospace Ltd

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Page 3

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 28/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 13/03/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/4/5

R12-04-5

Dart Aerospace Ltd

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Picklist Print

February-28-12 10:36:12 AM

Page 1

Work Order ID: 80720

80720

Parent Item: D4155-1

D4155-1

Parent Item Name: Bar

Start Date: 28/02/2012

Required Date: 13/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC
11.04.14 as per dwg revB DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	491.6000	7.6333	32.14021			

M304B0 250x0 500

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT006

491.6

120696

491.6

33.0 12-04-04

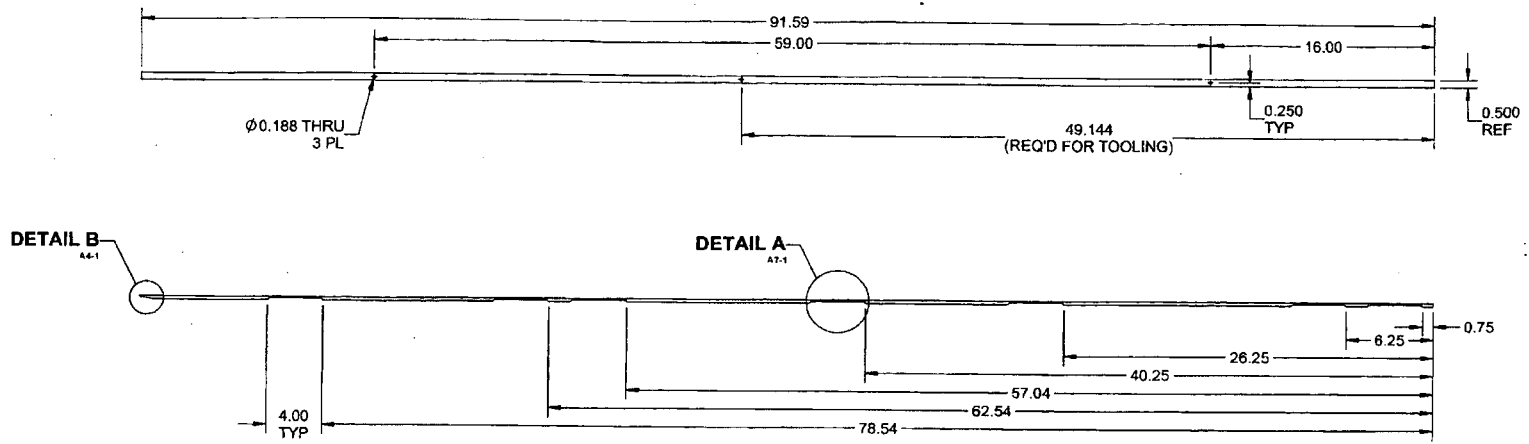
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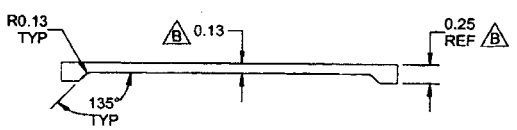
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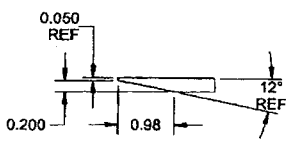
NOTE: Date & initial all entries



D4155-1 BAR



DETAIL A
SCALE 2X, TYP



DETAIL B
SCALE 2X

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X0.500
 - 2) FINISH : NONE
 - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION : NONE
 - 7) WEIGHT : 2.82 lbs

80720 MJS
12/02/28
RELEASED
2011-04-13

B	CHANGED MANUFACTURING PROCESS, MATERIAL WAS 0.50 THICK (A6-1); 0.25 REF WAS 0.20 (B6-1); 0.13 WAS 0.08 (B7-1)	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	5		
CHECKED	7		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.04.05		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA
DRAWING NO. **D4155**
TITLE **BAR**
REV. B
SHEET 1 OF 1
SCALE
NTS
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